

Work Order ID 129333

Tuesday, February 03, 2015 1:40:27 PM

129333

Page 1

Item ID: D3296-041B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, Blank
Start Date: 2/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/9/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: WVF Date: 15-2-3 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	B								

100 0.00

100

Small Fab

Small Fab

Small Fab

Memo

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

*****DO NOT DRILL HOLES ON TOP HINGE*****

0.00

IX 15/02/05 DAS 36 9-89

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

(1) DAS 38 9-89

FEB 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Page 2

Item ID: D3296-041B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, Blank
Start Date: 2/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/9/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M129777</i> Memo START TIME: <i>3:20</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>3:50</i>	0.00 0.00				<i>1</i>	<i>0</i>	<i>15-2-9</i>	DAS 34 9-89
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1X</i>		<i>15/02/10</i>	DAS 36 9-89
140 *140* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3296	0.00 0.00				<i>1X</i>		<i>15/02/10</i>	DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129333***129333***

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Tuesday, February 03, 2015 1:40:27 PM

Item ID: D3296-041B

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly, Blank

Start Date: 2/3/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/9/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O 0.00

150

QC Memo 0.00

Quality Control

① 15-02-10
DAS
9
9-89

160 Identify as per dwg & Stock Location: _____ 0.00

160

Packaging Memo 0.00

Packaging

PP 129330

FEB 10 2015

DAS
06
9-89

170 QC21- Final Inspection - Work Order Release 0.00

170

QC Memo 0.00

Quality Control

MCS 15-02-10

15-02-10

DQA: _____ Date: _____



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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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• Picklist Print

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Page 1

Work Order ID: 129333

129333

Parent Item: D3296-041B

D3296-041B

Parent Item Name: Door Assembly, Blank

Start Date: 2/3/2015

Required Date: 2/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137 *D2137* Decal(No Step)		Manufactured	No			100	Each	13.0000	1	1		15/02/10	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		13							
				115783		1							
				120383		12							
D2419 *D2419* Handle		Manufactured	No			100	Each	2.0000	1	1		15/02/10	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
				123422		2							
D2462 *D2462* Seal (Per foot)		Manufactured	No			100	f	507.8000	2.8166	3		15/02/10	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA2		0.8							
				48530		0.8							
				ST409		7							
				98802		7							
				ST638		500							
				115832		500							
D2728-1 *D2728-1* Dart Logo Label Small		Manufactured	Yes			100	Each	0.0000	0	0		15/02/10	DAS 36 9-89

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 129333

129333

Parent Item: D3296-041B

D3296-041B

Parent Item Name: Door Assembly, Blank

Start Date: 2/3/2015

Required Date: 2/9/2015

Start Qty: 1.00

Required Qty: 1.00

D3161-7 Manufactured No

100 Each 2.0000 1 1

D3161-7

Hinge 14.0"

**

15/02/05 DAS 36 9-89

Location

Loc Qty

Loc Code

ST487

2

115810

2

D3161-9 Manufactured No

100 Each 4.0000 1 1

D3161-9

Hinge 17.0"

**

15/02/05 DAS 36 9-89

Location

Loc Qty

Loc Code

ST487

4

117238

4

D3296-1 Manufactured No

100 Each 11.0000 1 1

D3296-1

Door Panel

**

15/02/05 DAS 36 9-89

Location

Loc Qty

Loc Code

ST489

11

120422

11

D3296-3 Manufactured No

100 Each 0.0000 1 1

D3296-3

Door Panel

**

15/02/05 DAS 36 9-89

B129334
(12)

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Parent Item: D3296-041B

D3296-041B

Parent Item Name: Door Assembly, Blank

Start Date: 2/3/2015

Required Date: 2/9/2015

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-4

Purchased

No

100

Each

6,999.000

25

25

DAS

MS20470AD4-4

Rivet, Universal Head

**

15/02/05

36

9-89

Location

Loc Qty

Loc Code

CCK004

4560

M125445

4560

GA

2426

M130224

2426

ST310

13

118614

13

MS20470AD4-6

Purchased

No

100

Each

1,139.000

1

1

DAS

MS20470AD4-6

RIVET

**

15/02/10

36

9-89

Location

Loc Qty

Loc Code

CCK003

1037

m128754

1037

GA

102

127305

102

NAS1149DN632J

Purchased

No

100

Each

236.0000

1

1

DAS

NAS1149DN632.J

Washer

**

15/02/10

36

9-89

Location

Loc Qty

Loc Code

ST270

236

M127255

100

M128812

136

DQA: _____ Date: _____



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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____